

5/22

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23156
<b>Description:</b> Gas Spring	<b>Part Number:</b>	D2807
<b>Dwg:</b> D2807 Rev. C	<b>Qty:</b>	2526
Page 1 of 1		


Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	WJ	05.07.19	25
2	PG	Issue P/O: <u>2007997</u> Order as per Dwg D2807 Possible supplier: ArvinMeritor Motion Control Systems <b>Material release note is required</b>	WJ	05.06.09	25
3	RG	Receive and Inspect for transit damage <b>Ensure the material release note is attached</b>	DL	05/07/19	25
4	QC6	Inspect dimensions as per Dwg D2807	SB	05/08/15	26
5	GA	Install lugs and crimp as per Dwg D2807 <b>Pick:</b> Qty Part Number Description Batch 2 D2807-3 Lug 1223915	SB	05/08/15	26
6	QC5	Inspect work to Step 5	SB	05.08.15	26
7	ST	Identify and Stock	SB	05/08/15	26
8	AC	Cost / part: <u>33.79</u>	SB	05/08/17	26
9	DC	Close W/O <u>30.75</u> Inspect Level 21	SB	05/08/16	26

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Added step 6	EC	
C	05.04.28	Reformat; Added Step 6 & 7	KJ/JLM	
D	05.06.21	Removed painting; Changed supplier	KJ/JLM	

RELEASED  
15-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 05/08/17

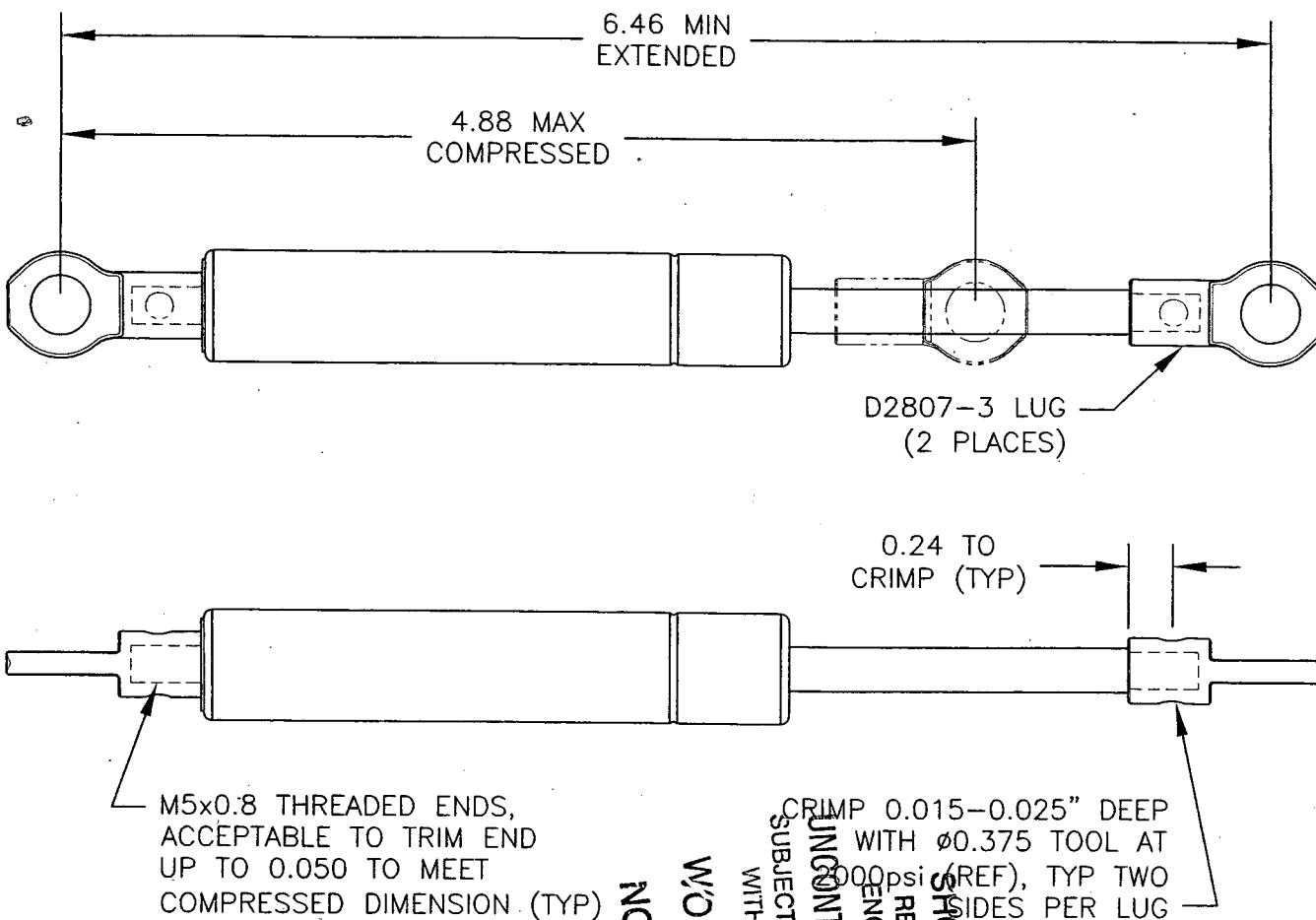
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



RELEASED  
#05-06-16

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAMKESBURY, ONTARIO, CANADA
DATE	05.05.25	DRAWING NO.	D2807	REV. C
		TITLE	GAS SPRING	SHEET 1 OF 2
A	00.11.03	SCALE	1:1	
B	05.03.16			
C	05.05.25			



### D2807 GAS SPRING

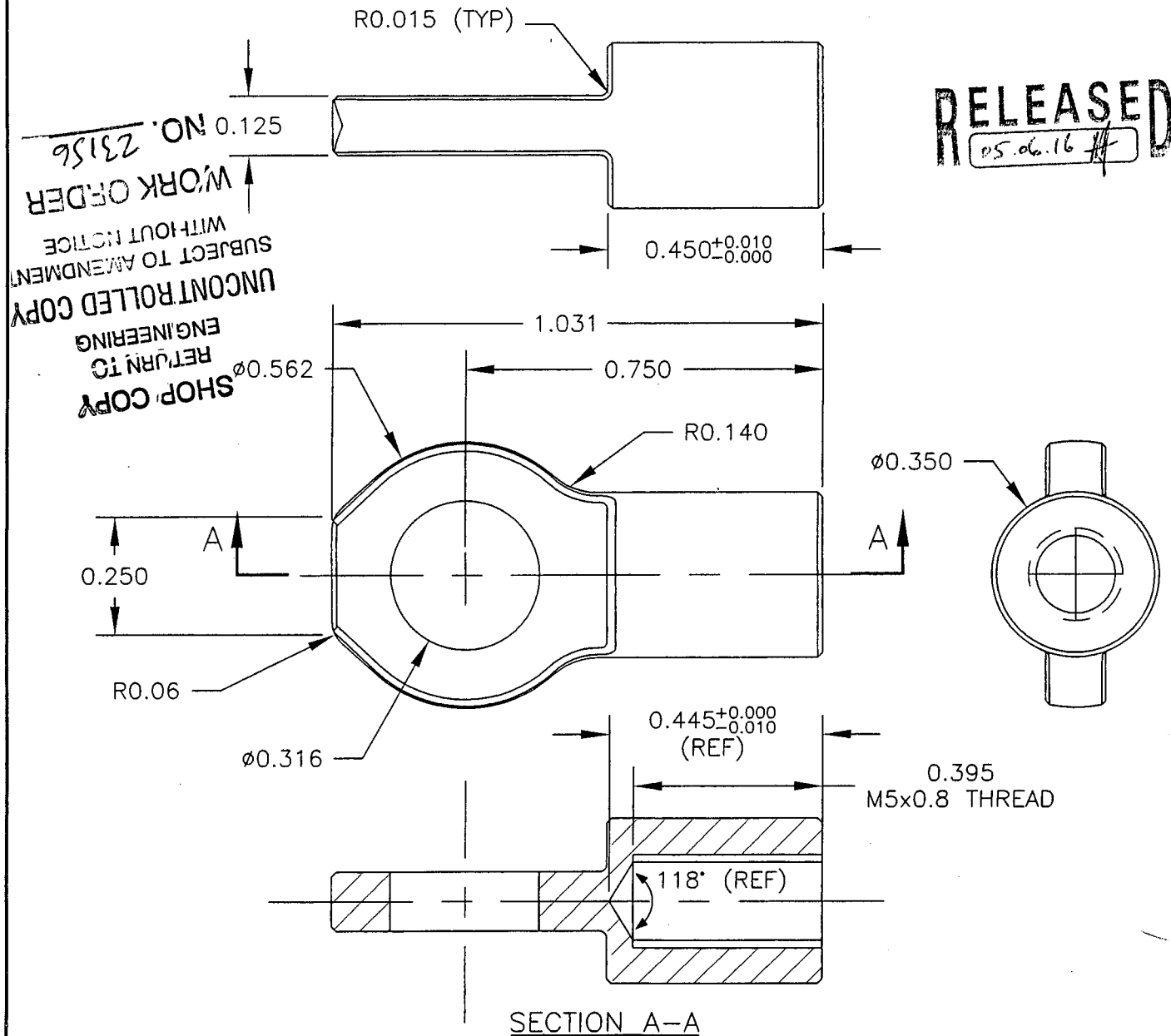
- 1) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX  
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK  
P/N: SXF6S6050080S6L-115N  
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	TITLE GAS SPRING		SCALE 3:1



### D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

May 06, 2005  
09:55 am

Work Order No : 0023156  
Project Name : D2807  
Project For : 522  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2807  
Description : Support Prop  
Manufactured : Yes  
Amount Req'd : 58  
Amount Done : 0  
Start Date : 05-04-05  
Est Finish Date : 05-31-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



5/22

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23156
<b>Description:</b> Gas Spring		<b>Part Number:</b>	D2807
<b>Dwg:</b> D2807 Rev. B <i>Rev. L. 05.07.19</i>		<b>Qty:</b>	23
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	AP	05/05/09	23
2	PG	Issue P/O: <u>2007997</u> <b>**Note: Do not ship by air**</b> <b>**Allow an extra 7 to 10 business days for shipping**</b> Order as per Dwg D2807 Possible supplier: Spring Lift, P/N SL-4-40 (40 lb load) <b>Material release note is required</b>		05.05.09	25
3	RG	Receive and inspect for transit damage <b>Ensure the material release note is attached</b>	DL	05/07/09	25
4	QC6	Inspect dimensions as per Dwg D2807 and test spring is 40lb			
5	FP	Open hole as per Dwg D2807 and touch up with paint			
6	FP	Mask, prime and paint as per Dwg D2807 using Plasti-Kote "Rust Not" primer and Plasti-Kote "Super Enamel" T1 Gloss Black Plasti-Kote "Rust Not" Batch: _____ Plasti-Kote "Super Enamel" Batch: _____			
7	QC3	Inspect Paint			
8	PK	Identify and Stock			
9	AC	Cost / part: _____			
10	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Added step 6	EC	
C	05.04.28	Reformat; Added Step 6 & 7	KJ/JLM	

RELEASED  
05.04.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_